

Split

79922

Page 1

Work Order ID 79922-2

February-08-12 9:23:42 AM

Item ID: D4456-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Raingutter, LH

Start Date: 17/02/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: M.LJ

Date: 17/02/08

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4456

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: 1A

Prog Rev: 1A

2-Deburr if necessary

B12-2-14

B12-2-29

(23)

(20)

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B12-2-14

B12-2-29

(23)

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S. 2/20/14

S. 2/20/14

counter
(23)counter
(23)

W/O: 79922-2

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 4456-3 PAR #: _____ Fault Category: Small Fast/water Set NCR: Yes No DQA: 10/12/13 Date: 12/08/13
 Resolution: Scrap Disposition: Scrap QA: N/C Closed 10 Date: 12/8/14

WORK ORDER NON-CONFORMANCE (NCR)

NCR: 12.11076

54.96 x 2 = 109.92

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.12.23	120	Material used was 6061 T6 / should be 6061 T4 RC 60A	S 12/08/13 057012	Scrap & destroy Q4 12 + Rehm. 6061 T6 m 120777	AB 12-2-20	S 12/08/13 057012	S 12/08/13 057012	M/L 12-02-23

NOTE: Date & Initial all entries

Work Order ID 79922

February-08-12 9:23:42 AM

79922

Page 2

Item ID: D4456-3 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Raingutter, LH
 Start Date: 17/02/2012 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 17/02/2012 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	NC BRAKE								
Small Fab	Memo	0.00				(10) 15	FF FF	12- 12-05-16	
Small Fab	1- Form as per dwg using DT9789 2- After forming cut off tabs as per dwg								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00				(45) 3			
Quality Control									
144		0.00							
144	Outsource process - Heat Treat								
Outsource1	Memo	0.00							
Outsource process - Heat Treat									

8/2/05/16

P10:17010

CL 12/05/17 15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79922

February-08-12 9:23:42 AM

79922

Page 3

Item ID: D4456-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Raingutter, LH
 Start Date: 17/02/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 17/02/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

146	Receive & Inspect for Damage & Mat'l Certs	0.00							
146									
Packaging	Memo	0.00							
Packaging									

150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									

160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

1/4/12/12 (10)

15 12-8-8

15x 12-8-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79922

79922

Page 4

February-08-12 9:23:42 AM

Item ID: D4456-3 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Raingutter, LH
 Start Date: 17/02/2012 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 17/02/2012 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <i>5110</i>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

15x

SP
12-8-9.

12/8/10 *JD*

12-08-9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-08-12 9:23:46 AM

Page 1

Work Order ID: 79922

79922

Parent Item: D4456-3

D4456-3

Parent Item Name: Aft Raingutter, LH

Start Date: 17/02/2012

Required Date: 17/02/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 11.11.21 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M60610S.032		Purchased	No			100	sf	41.0000	0.125	2.631579			

M60610S 032

6061 0 SHEET .032

**

B12-2-14

Location

Loc Qty

Loc Code

MAT021

41

119686

41

6061.032 T.O

120777

~~120777~~

120777

23

(20)

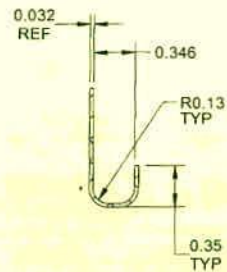
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

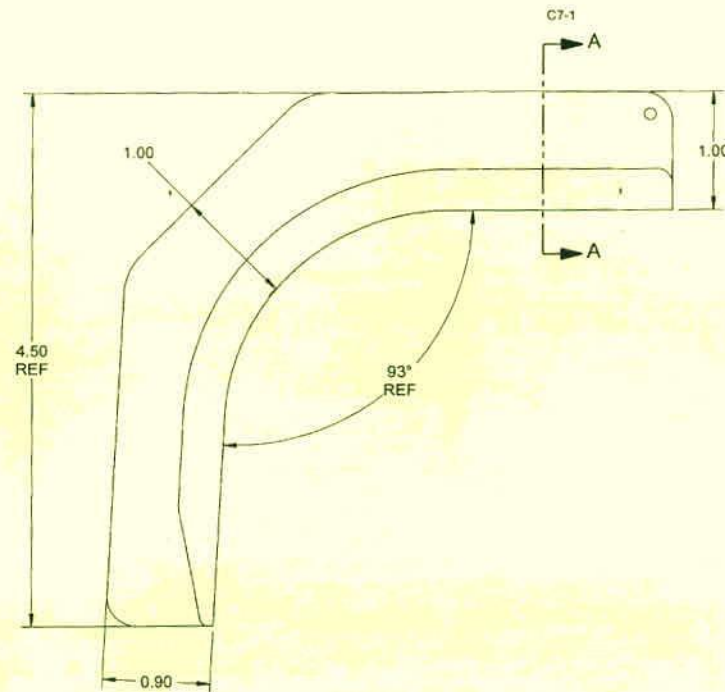
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



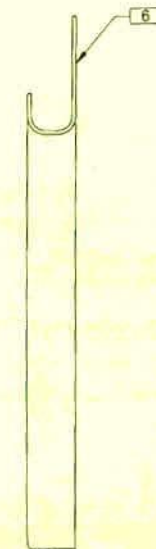
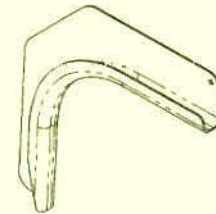
SECTION A-A D4--1



D4456-1 FWD RAINGUTTER, LH

NOTES:

- 1) MATERIAL: MAKE FROM D4456-1F FLAT PATTERN
HEAT TREAT TO 6061-T6 CONDITION AFTER FORMING
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING



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NO. 1992B
1012-02-1

RELEASED
2012-01-17
JUN

A		NEW ISSUE	RF	11.11.17
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.		
DRAWN	RF	KENT, WA		
CHECKED	RF	DRAWING NO.	REV. A	
MFG. APPR.	RF	D4456	SHEET 1 OF 8	
APPROVED	RF	TITLE	SCALE	
DE APPR.	RF	RAINGUTTER	NTS	
DATE	11.11.17		<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

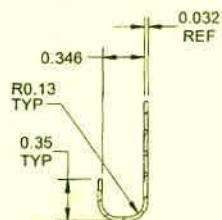
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

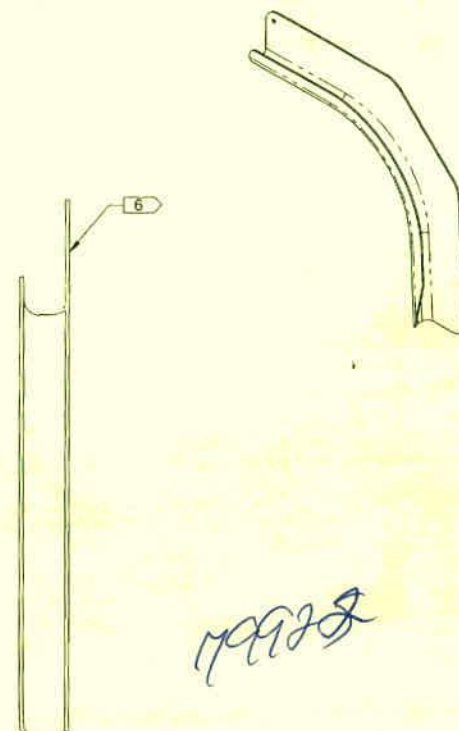
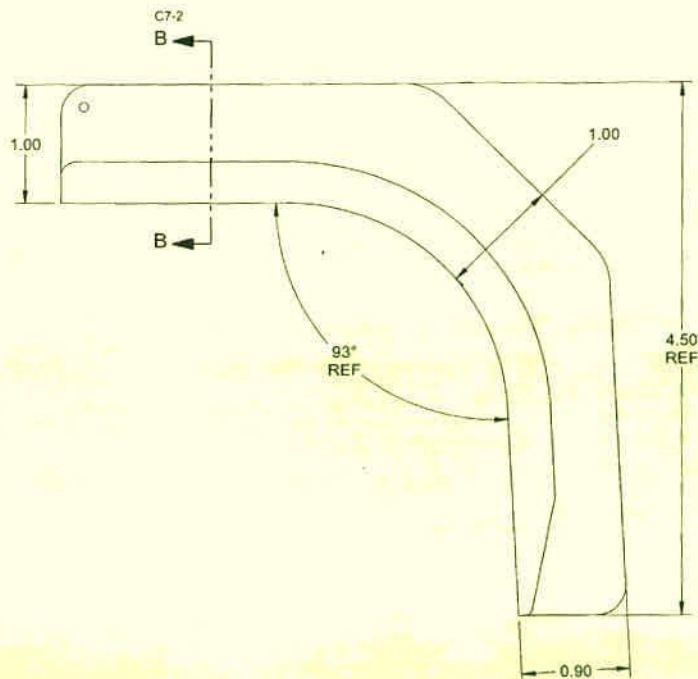
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NOR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION B-B D6-2



100028

RELEASED
2012-01-17

D4456-2 FWD RAINGUTTER, RH

NOTES:

- 1) MATERIAL: MAKE FROM D4456-1F FLAT PATTERN
HEAT TREAT TO 6061-T6 CONDITION AFTER FORMING
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

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MFG. APPR.	<i>[Signature]</i>	D4456	SHEET 2 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD RAINGUTTER, RH	1:1
DATE	11.11.17	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

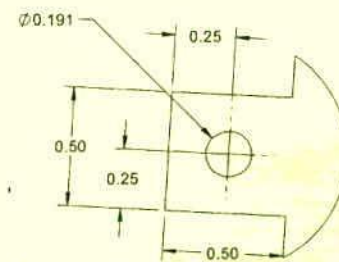
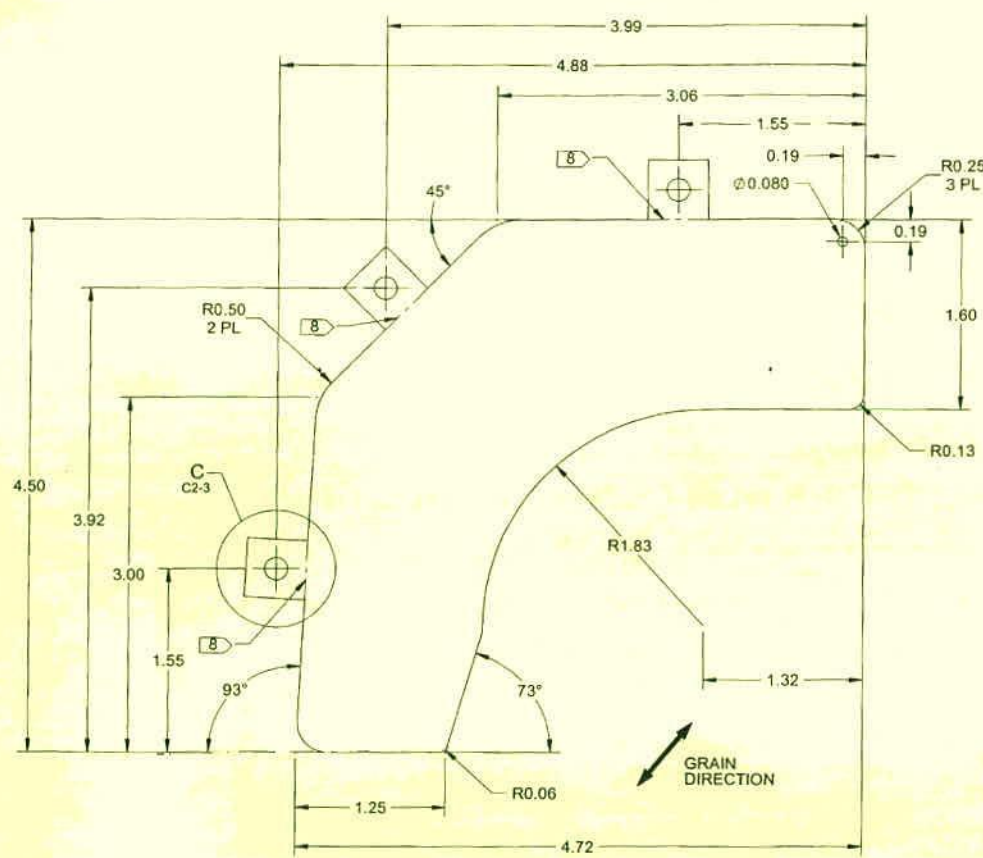
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL C
TYP
C7-3
C8-3
D5-3

1992

RELEASE
2012-01-17
JW

D4456-1F FWD RAINGUTTER FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.032 THICK
PER AMS QQ-A-250/11 OR AMS 4025
REF DART SPEC M6061-OS.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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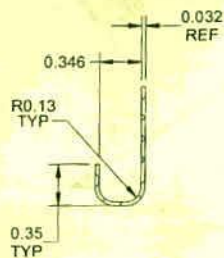
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

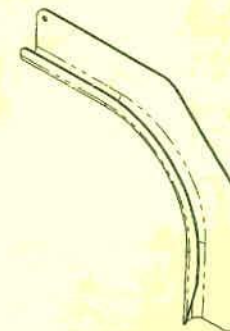
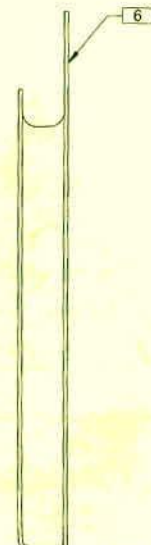
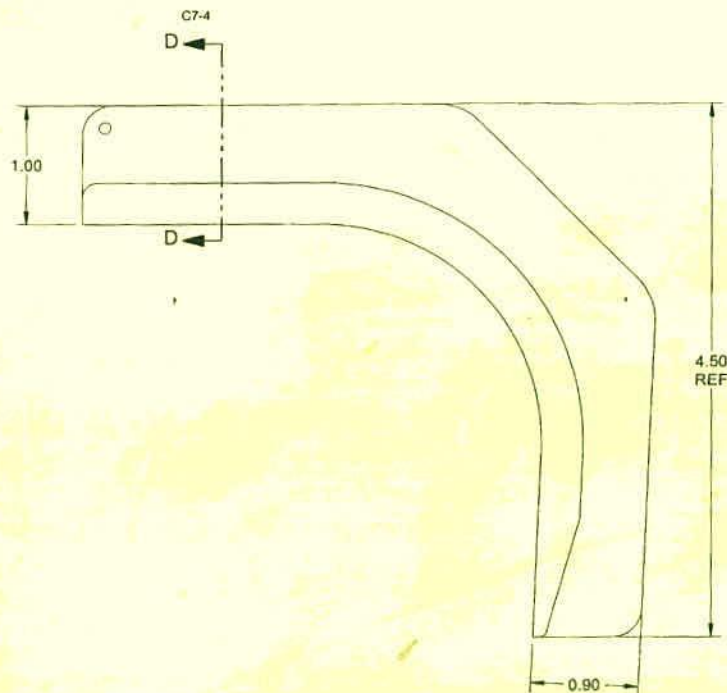
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION D-D C6-4



D4456-3 AFT RAINGUTTER, LH

RELEASED
2012-01-17

NOTES:

- 1) MATERIAL: MAKE FROM D4456-3F FLAT PATTERN
HEAT TREAT TO 6061-T6 CONDITION AFTER FORMING
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

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MFG. APPR.	<i>[Signature]</i>	D4456	SHEET 4 OF 8
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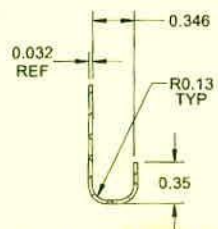
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

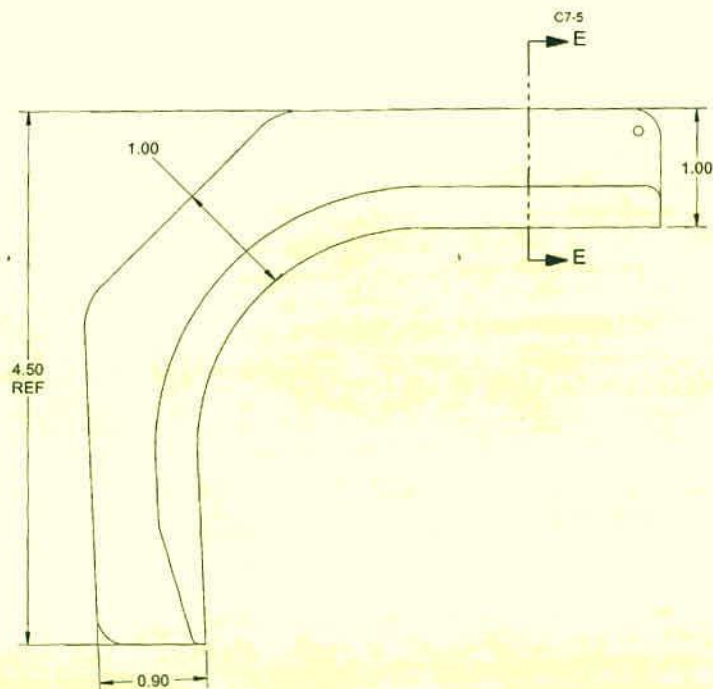
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

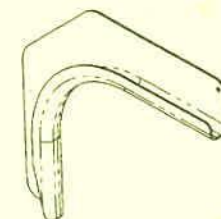
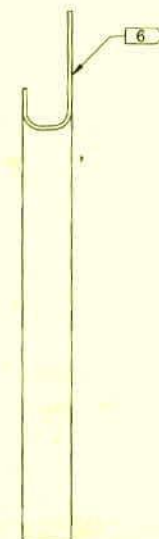
NOTE: Date & initial all entries



SECTION E-E D4-5



D4456-4 AFT RAINGUTTER, RH



79922

PLEASE
16 JUN 2012 - 01 17
WV

NOTES:

- 1) MATERIAL: MAKE FROM D4456-3F FLAT PATTERN
HEAT TREAT TO 8061-T6 CONDITION AFTER FORMING
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
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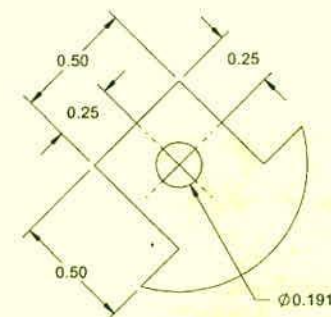
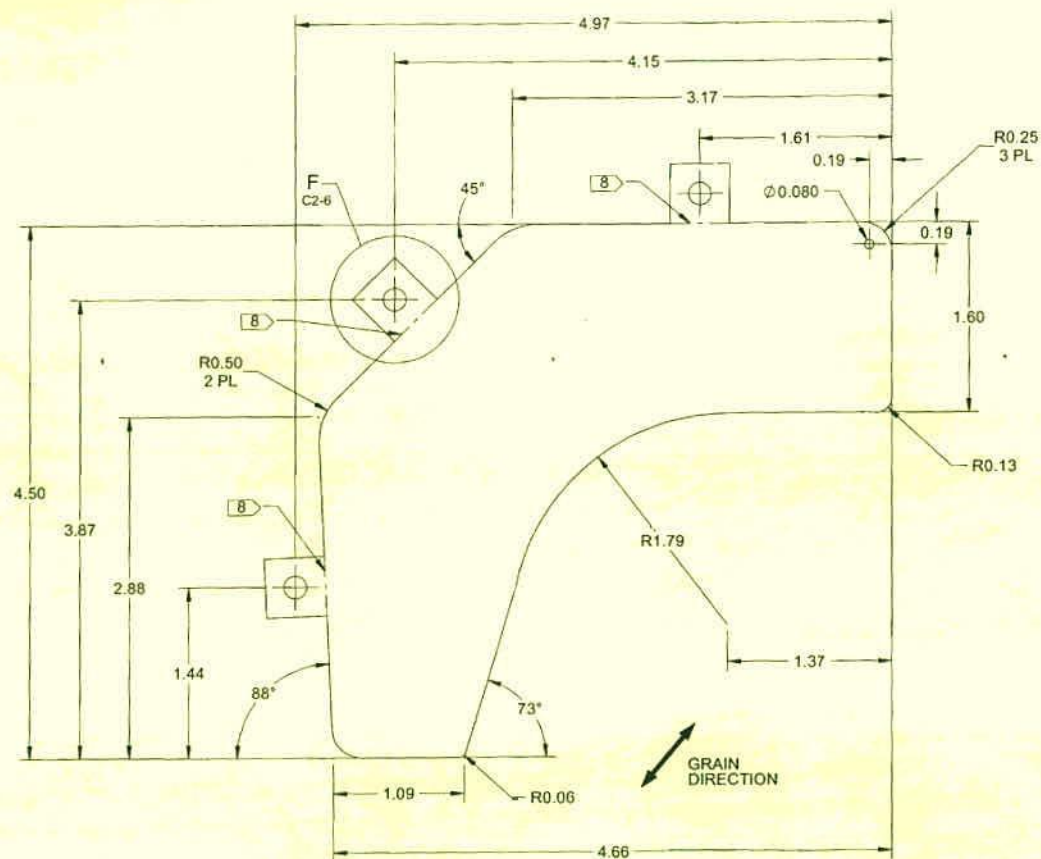
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL F
TYP

79928

PLEASE
LD 2012-01-17
JMP

D4456-3F AFT RAINGUTTER FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.032 THICK
PER AMS QQ-A-250/11 OR AMS 4025
REF DART SPEC M6061-OS.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4456	SHEET 6 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RAINGUTTER	NTS
DATE	11.11.17	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

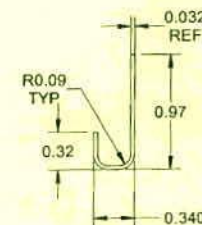
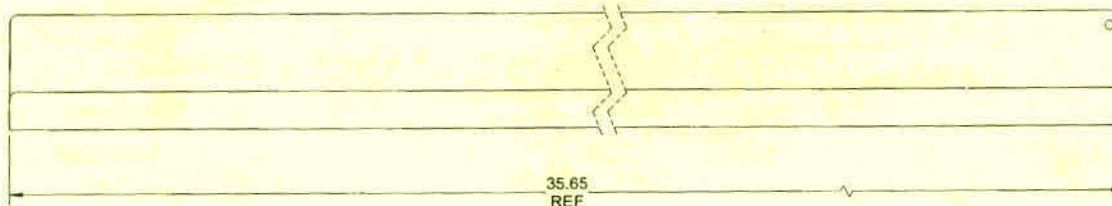
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



79925

D4456-5 CENTER RAINGUTTER

RELEASED
2012-01-17

NOTES:

- 1) MATERIAL: MAKE FROM D4456-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.17 lbs
- 8) TRIM TABS ON THE HIDDEN LINES AFTER FORMING

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED		DRAWING NO. D4456	REV. A
MFG. APPR.		TITLE	SHEET 7 OF 8
APPROVED		RAINGUTTER	SCALE
DE APPR.			NTS
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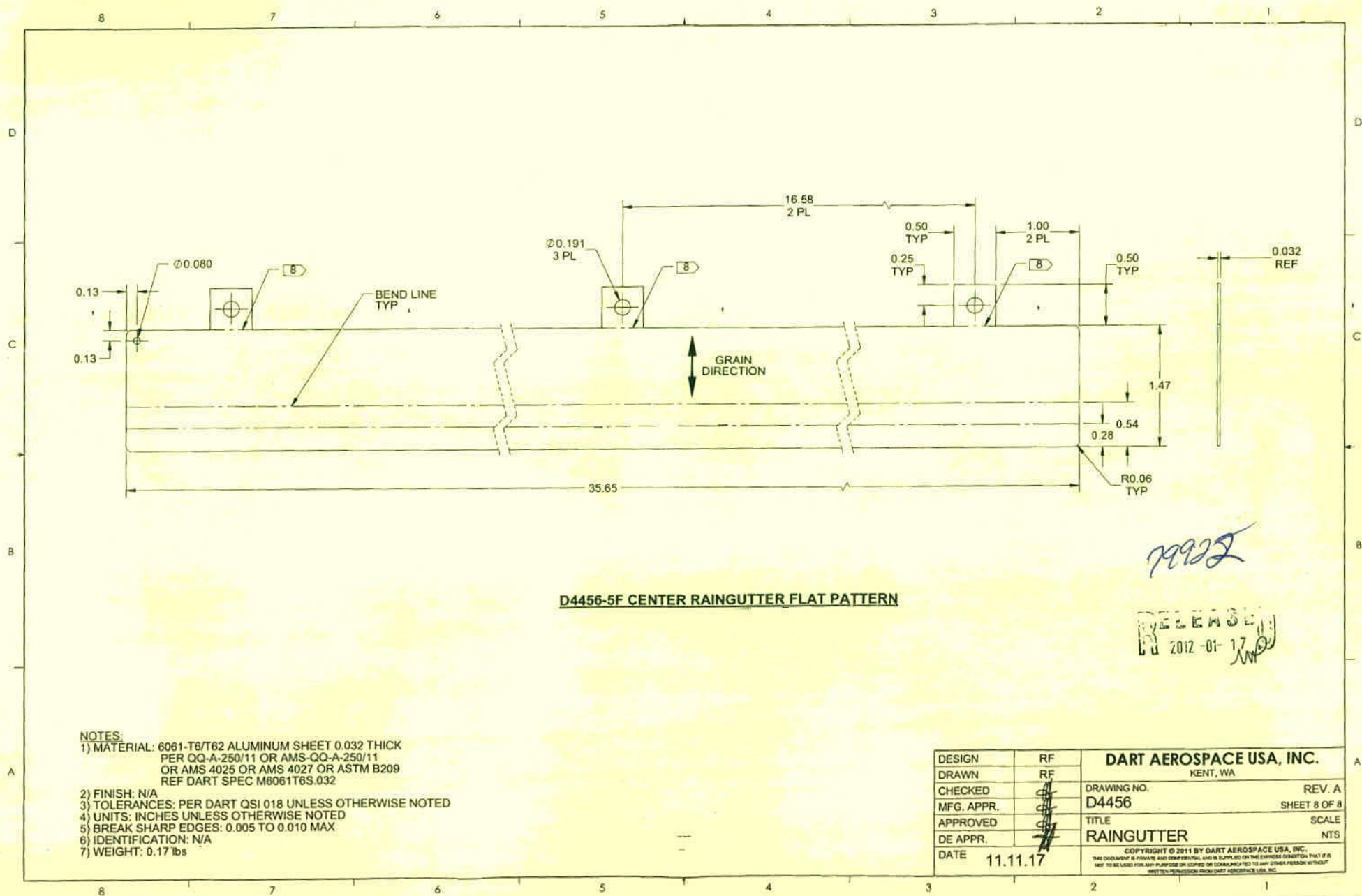
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



79925

RELEASE
2012-01-17

NOTES

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4456	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		RAINGUTTER	NTS
DATE	11.11.17	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS OR UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 79922

Description: ART RAIN GUTTER LH

Part Number: DH456-3

Inspection Dwg: DH456-3, Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
① .080	+ .004 - .001	.081	✓		✓	Boz
② .191	+ .001 - .001	.194	✓		✓	
.50	± .030	.502	✓		✓	
.25	± .030	.248	✓		✓	
1.44	± .03	1.446	✓		✓	
3.87	± .030	3.871	✓		✓	
4.50	± .030	4.50	✓		✓	
1.61	± .030	1.614	✓		✓	
4.15	± .030	4.147	✓		✓	
4.97	± .030	4.971	✓		✓	
1.60	± .030	1.606	✓		✓	
.19	± .030	.19	✓		✓	
4.66	± .030	4.66	✓		✓	
.03	± .010	.030	✓		✓	

Measured by: IB

Audited by: S

Prototype Approval:

Date: 12-2-14

Date: 12/2/14

Date:

Rev

Date

Change

Revised by

Approved

A

New Issue

KJULM

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Recu de Livraison

Order	Shipper	Shipping Seq
176131	1	61434

Shipped Complete

Customer

215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

Shipped To:

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

Purchase Order Number	Customer Shipper No.	Material Type	Order Date	Carrier
PO17010		AL-6061	2012/5/18	FEDEX
Quantity	Part No. / Part Name / Part Description			Pounds
15	D4456-3 AFT RAINGUTTER LH CONTENANT: 1 SAC DE PLASTIQUE			62

Container Type	# Of Containers	Container Comments
SAC DE PLASTIQUE	1	

PACKING

Quantity Shipped: 15
Pounds Shipped: 0,62
Quantity Remaining: 0
Pounds Remaining: 0.00

Quantity Shipped: 15

Pounds Shipped: 0,62

Nature:

Date:

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
176131	1

CLIENT / customer 215
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
PO17010		AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

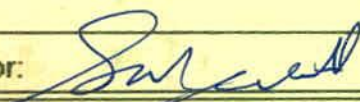
SOL ANNEAL
SINGLE AGING TO CONDITION T6

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	40 - 50 %IACS	15	46 - 47 %IACS
HARDNESS	85 HREW MIN	15	90 - 92 HREW
			DURETEE MESUREE EN HR15TW = 78.5-79.5 HR15TW

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
15	0.62	D4456-3 AFT RAINGUTTER LH CONTENANT: 1 SAC DE PLASTIQUE

COMMENTAIRES / comments

INSPECTEUR / inspector:




DATE: 2012-06-01

ИЗВЕЩЕНИЕ



СОВЕТСКИЙ СОЮЗ

ОБЩЕСТВЕННАЯ РАБОТА

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